

Work Order ID 57145

Tuesday, March 23, 2010 4:14:45 PM



A.S.A - S

for back

Page 1

Item ID: D3953-21

Accept



Setup Start



Revision ID:

Stop



Item Name: Gas Spring Bracket

Start Date: 3/24/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 3/29/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-3-23 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3953

C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3953

Dwg Rev:

Prog Rev:

2-Deburr if necessary

10-3-30
10/03/30

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-3-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

8 10/6/30

counters
(X22)

Memo

0.00

130



Small Fab

Small Fab

Memo

1- CHAMFER HOLE AS PER DWG

2- DEBURR IF NECESSARY

0.00

0.00

8 10/6/31 (22)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8 10/6/31

counters
(X22)

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Page 3

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Cust Item ID:

Required Date: 3/29/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Packaging

Identify as per dwg & Stock Location: ST102

0.00

Memo

0.00

CY 10/3/31 22

Packaging

160



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/04/06

PA 10-H-5
22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 23, 2010 4:14:44 PM

Page 1

Work Order ID: 57145



Parent Item: D3953-21



Parent Item Name: Gas Spring Bracket

Start Date: 3/24/2010

Required Date: 3/29/2010

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
dwg revC DD 10.03.02 verified by:EC

IPP Rev:B as per

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	47.3194	0.1516	.5		



304/316 0.125 Sheet



18103-30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT19

112663

47.3194

47.3194

52

112663

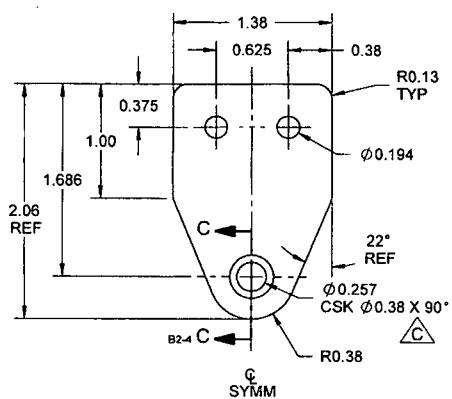
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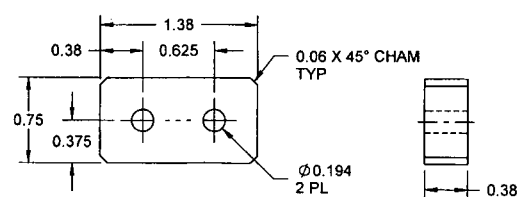
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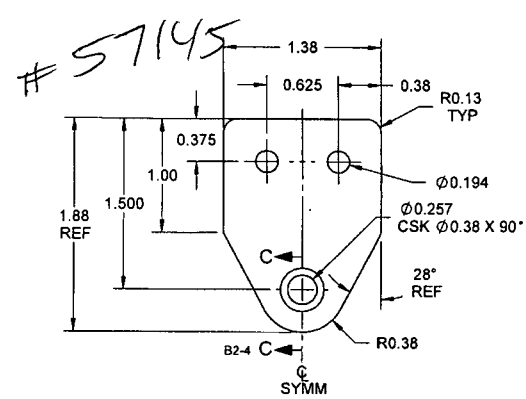
NOTE: Date & initial all entries



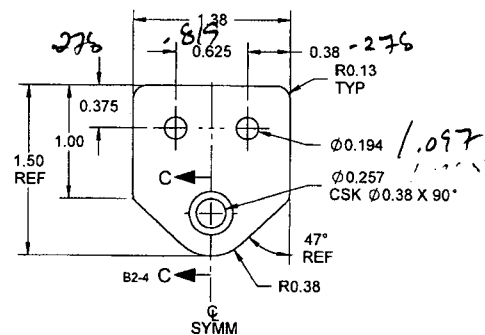
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



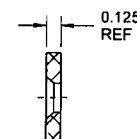
D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)



SECTION C-C

NOTES:

1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH.
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -15: 0.08 lbs
-17: 0.10 lbs
-19: 0.07 lbs
-21: 0.06 lbs

RELEASED
2010-02-26

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>B</i>	D3953	SHEET 4 OF 4
APPROVED	<i>#</i>	TITLE	SCALE
DE APPR.	<i>#</i>	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL OR OTHER PURPOSE WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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